UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
REGION 4
ATLANTA FEDERAL CENTER
61 FORSYTH STREET
ATLANTA, GEORGIA 30303-8960

FEB 0 1 2013

CERTIFIED MAIL
RETURN RECEIPT REQUESTED

Mr. Jimmy Hobby,
Environmental, Health and Safety Supervisor
Westlake Chemical
2468 Industrial Parkway
Calvert City, Kentucky 42029

SUBJ: RCRA Compliance Evaluation Inspection
Westlake Chemical
EPA ID No.: KYD 985 072 008

Dear Mr. Hobby:

Enclosed is a copy of the U.S. Environmental Protection Agency inspection report documenting the results of the November 7, 2012, inspection of Westlake Chemical, 2468 Industrial Parkway, in Calvert City, Kentucky. This was an EPA lead Compliance Evaluation Inspection for the purpose of evaluating the facility's compliance with the applicable Resource Conservation and Recovery Act (RCRA) regulations.

Enclosed is the CEI report that indicates violations of RCRA were discovered. A copy of this report has been forwarded to the Kentucky Department of Environmental Protection (KDEP).

If you have any questions regarding this matter, please contact Alan Newman, of my staff, by phone at (404) 562-8589 or by email at newman.alan@epa.gov.

Sincerely,

Doug C. McCurry
Chief, North Enforcement and Compliance Section
RCRA and OPA Enforcement and Compliance Branch

Enclosure

cc: Gary Morgan, KDEP Paducah w/enclosure
Duke York, KDEP Frankfort w/enclosure
Anthony Hatton, KDEP Frankfort w/enclosure

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Mr. Anthony Hatton, Director
Division of Waste Management
Kentucky Department for Environmental Protection
200 Fair Oaks Lane, 2nd Floor
Frankfort, Kentucky 40601

SUBJ: RCRA Compliance Evaluation Inspection
Westlake Chemical
EPA ID No.: KYD 985 072 008

Dear Mr. Hatton:

On November 7, 2012, a U.S. Environmental Protection Agency lead Compliance Evaluation Inspection was conducted at the Westlake Chemical in Calvert City, Kentucky to determine the facility's compliance status with the Resource Conservation and Recovery Act (RCRA). Enclosed is the CEI report that indicates violations of RCRA were discovered.

If you have any questions regarding this matter, please contact Alan Newman, of my staff, by phone at (404) 562-8589 or by email at newman.alan@epa.gov.

Sincerely,

Doug C. McCurry
Chief, North Enforcement and Compliance Section
RCRA and OPA Enforcement and Compliance Branch

Enclosure

RCRA Inspection Report

1) Inspectors and Authors of the Report

Alan Newman
Environmental Engineer
newman.alan@epa.gov
(404) 562-8589

RCRA and OPA Enforcement and Compliance Branch
US EPA Region 4 AFC – 10th Floor
61 Forsyth Street, SW
Atlanta, Georgia 30303

2) Facility Information

Westlake Chemical
2468 Industrial Parkway
Calvert City, Kentucky 42029
EPA ID No.: KYD 985 072 008

3) Responsible Official

Jimmy Hobby
Environmental, Health and Safety Supervisor
Westlake Chemical
Cell: (270) 703-7610
jhobby@westlake.com

4) Inspection Participants

Jimmy Hobby	Westlake Chemical
Will Woods	Westlake Chemical
Chris Lepore	Westlake Chemical
Joe Skees	Westlake Chemical
Wendell Cowan	Westlake Chemical
Gary Morgan	KDEP – Paducah Office
Alan Newman	US EPA Region 4

5) Date and Time of Inspection

November 7, 2012, at 8:30 a.m.

6) Applicable Regulations

Sections 3002 and 3007 of RCRA 40 C.F.R. Parts 260 through 268, 270, 273 and 279; and the Kentucky Revised Statues and Title 401 Kentucky Administrative Regulations (KAR) Chapters 30-40.

7) **Purpose of Inspection**

The purpose of this inspection was to conduct an unannounced Resource Conservation and Recovery Act (RCRA) Compliance Evaluation Inspection (CEI) to determine the Westlake Chemical's compliance with the applicable regulations.

8) **Facility Description**

Westlake Chemical (Westlake) is a large quantity generator of hazardous waste and manufactures poly vinyl chloride (PVC). The facility is made up of five plants: the Ethylene plant, the Chlor-allyl plant, the monomer plant, the acid reclamation, and the PVC plant. The PVC plant is located nearby but off-site. This process begins by manufacturing Chlorine and Ethylene. Westlake adds water to rock salt brought in by barge from Louisiana to make a brine solution. The brine solution is cleaned and broken apart into Chlorine, caustic, and Hydrogen using electrolysis. Westlake cracks propane which arrives via pipeline and distills the different chains to make ethylene and other co-products. The Chlorine and Ethylene are combined to make ethylene dichloride (EDC). EDC is cracked thermally to produce vinyl chloride.

Westlake employs approximately 350 workers working four rotating 12 hour shifts who operate the facility 24 hours a day 7 days a week 365 days a year. The facility consists of approximately 179 acres.

9) **Previous Inspection History**

On December 19, 2011, and July 19, 2010, KDEP conducted CEIs at the Westlake. There were no violations noted during these inspections.

10) **Findings**

After presenting their credentials to Jimmy Hobby, and explaining the purpose of the inspection, the inspectors requested an explanation of the operations and a tour of the facility. The inspectors performed a walk-through inspection of the facility. Below is a description of the observations made during the walk-through.

Westlake generates hazardous waste from product spills, aerosol cans, waste fuel oil and rags, reboiler coke, furnace coke, oily waste, and laboratory wastes. Westlake operates two less than 90-day hazardous waste container storage areas and multiple satellite accumulation areas.

- Less than 90-day hazardous waste container storage – concrete floor, covered metal pole barn, fenced and locked

At the time of the inspection, Westlake was storing three 55-gallon containers in the less than 90-day hazardous waste container storage area: one 55-gallon container of Mercury contaminated debris dated 10/29/2012, one 55-gallon container of east cracking furnace dated 10/30/2012, and one 55-gallon container of spent laboratory solvent dated 11/2/2012. Additionally, Westlake was storing one 5-gallon container of mercury containing equipment dated 10/29/2012. These containers were in good condition, properly labeled, and closed.

Westlake was also storing universal waste batteries in three 5-gallon metal pails and lead acid batteries on pallets. The metal pails included one for lithium batteries dated 7/24/2012, one for Ni metal hydride batteries dated 7/25/2012, and one for Ni-Cad batteries dated September 17, 2012. There were no violations noted in this area. Additionally, there was one 5-gallon pail for alkaline batteries dated 7/20/2012.

- Less than 90 day hazardous waste Roll off storage area

At the time of the inspection there was one roll off of hazardous waste from the Cell Room that was dated 10/24/2012. This roll off was in good condition, properly labeled, and closed. There were no violations noted in this area.

- Satellite accumulation containers

The inspection team visited approximately 21 satellite accumulation areas for aerosol cans, waste fuel oil and rags, reboiler coke, furnace coke, oily waste, and laboratory wastes. The inspection team noted one area of concern during the tour of the satellite accumulation areas. In two locations, the fuel oil loading area and the ethylene maintenance shop, there were more than one 55-gallon containers of waste accumulating (photos 1-3). Satellite accumulation areas are limited to a total volume of 55 gallons. At the time of the inspection, neither location appeared to be storing more than 55 gallons of hazardous waste. Each container was properly labeled, in good condition, and closed. The inspection team suggested that the coupled containers be separated to be closer to their respective points of generation. Following the inspection, Westlake documented that they moved these containers away from one another and closer to their points of generation.

- Universal Waste Lamps

Westlake was storing universal waste lamps in approximately eight cylinders in the maintenance shop. The oldest date was 6/20/2012. These containers were closed and properly labeled. There were no violations noted with the universal waste lamps.

- Mechanics Shop

The inspection team noted that one container of used oil was not labeled near the Mechanics Shop. This labeling deficiency was corrected immediately. There was one media blast booth in this area used to clean parts. The material generated in this area will need to undergo a hazardous waste determination prior to disposal.

Westlake Chemical is in apparent violation of 401 KAR 44:020 Section 3(1) (40 C.F.R. § 279.22(c)(1)) for failing to label a container used to store used oil. Generator facilities of used oil must label or mark clearly each container and tank with the words "Used Oil".

- Record Review

The inspection team reviewed the facility records including the manifests for 2011 and 2012, the training records for seven employees, the contingency plan, the waste minimization report, and the less than 90-day hazardous waste container storage area inspections. There were no violations noted during the record review.

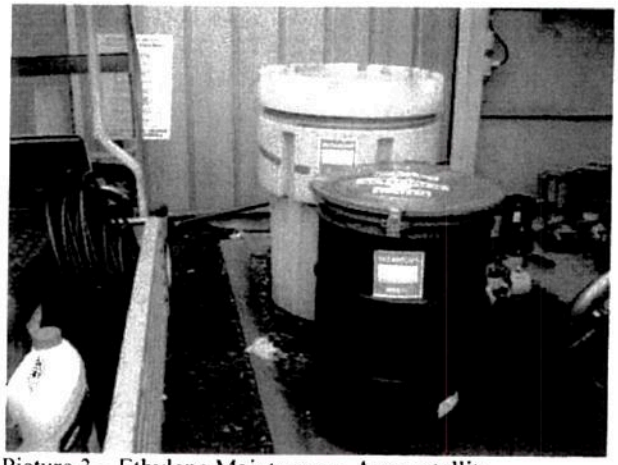
11) Signed

Alan R. Newman, Inspector — Date: 2/1/2013

12) Concurrence

Doug C. McCurry
Chief, North Enforcement and Compliance Section
RCRA and OPA Enforcement and Compliance Branch — Date: 2/1/13

Picture 1 – Fuel Oil Loading Area satellite accumulation containers.



Picture 3 – Ethylene Maintenance Area satellite accumulation containers.

Picture 2 – Fuel Oil Loading Area satellite accumulation containers.